

(19)



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European Patent Office  
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(11) Publication number:

**0 499 978 A2**

(12)

**EUROPEAN PATENT APPLICATION**(21) Application number: **92102492.3**(51) Int. Cl.<sup>5</sup>: **G02B 6/28**(22) Date of filing: **14.02.92**(30) Priority: **19.02.91 JP 24353/91**(43) Date of publication of application:  
**26.08.92 Bulletin 92/35**(84) Designated Contracting States:  
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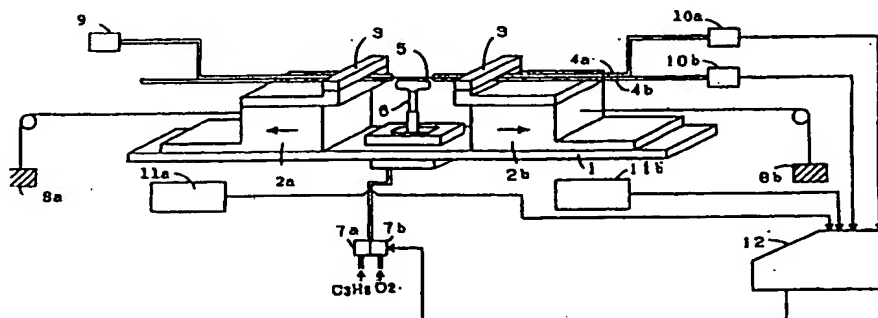
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(54) **Method of producing optical-fiber coupler.**

(57) The invention provides a method for producing an optical-fiber coupler with a preset branching ratio. The present invention relates to a method in which part of a plurality of optical fibers are made to closely contact with each other so as to form a coupler. The coupler is heated to thereby obtain a

predetermined branching ratio; the flow rate of a gas to be supplied to a heat source is increased/decreased by a quantity proportional to a difference between the drawing speed and a preset drawing speed while predetermined tension is applied to the optical fibers.

**FIGURE 1**

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## BACKGROUND OF THE INVENTION

### Field of the Invention

The present invention relates to a method of producing an optical-fiber coupler to be used, for example, in optical communications or light measurements.

### Description of Related Art

A fiber-type coupler is a device for branching/coupling light between a plurality of optical fibers. At present, a melt-drawing method is considered to be the most suitable for producing a single-mode fiber coupler ("The Latest Technique of Optical-Fiber Coupler", OPTORONICS, No.5, 1988, P.125). Such a melt-drawing method involves; partly removing the respective coatings of two optical fibers so as to form exposed portions; twisting the exposed portions so as to closely contact with each other or fixed so as to contact closely and parallel to each other; and, drawing this bundled portion while heating and fusing the bundled portion with a burner or the like.

At the same time, light which has been incident from one end of the optical fibers is measured at the other ends of the optical fibers so that the light branching ratio is detected. Drawing is stopped when a predetermined branching ratio is obtained. Finally, the optical fibers are fixed and made to adhere to a protection member to thereby produce a fiber-type coupler.

In the foregoing conventional method, optical fibers are drawn while only the branching ratio is being monitored. In such a method, however, the diameters of optical fibers decrease as the drawing advances, thereby increasing the drawing speed so that it is difficult to stop the drawing when the branching ratio has reached a desired, predetermined value. In the worst case, the optical fibers are broken.

Further, the refractive index of the heated glass differs from that of the finished product. This makes it impossible to measure the branching ratio of the heated product to create a finished, cooled product with a predetermined branching ratio. This makes it impossible to obtain a coupler having the branching ratio of a desired finished value.

### SUMMARY OF THE INVENTION

The present invention provides a method in which the problems of the conventional method described above are overcome and an optical-fiber coupler is produced stably, with the desired branching ratio, with high precision. Specifically, the present invention provides a method of produc-

ing an optical-fiber coupler in which part of a plurality of optical fibers are made to closely contact with each other so as to form a coupler forming portion. The coupler forming portion is then heated and drawn. The optical fibers are drawn by the method of the present invention at a drawing speed while receiving constant tension and while increasing/decreasing the flow rate of a flaming gas to be supplied to a heat source by a quantity proportional to a difference between the drawing speed and a preset drawing speed. The method of the present invention provides a computer feedback loop to adjust the heating rate as a function of the drawing speed and measured branching ratio.

In order to obtain the effects of the present invention, it is preferable that a branching ratio of a coupler is measured during heating and drawing so that the preset drawing speed is made to be a function of the branching ratio; that the function is established so that the drawing speed approaches zero as the branching ratio approaches a final target value; and that the heat source is a burner having a plurality of gas ejection outlets arranged along the axial direction of the optical fibers, the burner being fixed during heating.

### BRIEF DESCRIPTION OF THE DRAWINGS

Specific components in the figures are explained in more complete detail through the Detailed Description of the Preferred Embodiments, and hence, will not be repeated here.

In the accompanying drawings:

Fig. 1 is a perspective view of an apparatus for producing an optical-fiber coupler, for use in an embodiment of the present invention.

Fig. 2 is a graph showing an example of the relationship between the branching ratio SR and the set drawing speed  $V\phi$ , for use in the present invention.

Fig. 3 is a perspective view of a burner for use in the embodiment of the present invention.

Fig. 4 is a flow chart for explanation of a conventional producing process.

Fig. 5 is a flow chart for explanation of the process of the present invention.

### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

The method of the present invention is characterized by reference to Figure 1, wherein the drawing speed V of two optical fibers is measured during drawing of the optical fibers and the quantity W of gas of the flaming burner is increased/decreased by the quantity  $\Delta W$  of gas proportional to a difference between the measured speed and a preset drawing speed  $V\phi$  ( $W = W \pm$

$\Delta W$ ).

The drawing speed of an optical fiber is a function of the cross section of the optical fiber, the drawing tension, and the heating temperature.

According to the present invention, the drawing tension acting on two fibers constituting a coupler is made constant so that the drawing speed is always made to approach a set value. Controlling the flow rate of gas prevents the optical fibers from being broken by the rapid increase of the drawing speed when the optical fibers are heated and drawn causing the optical fibers to become thin.

From the results of experiments, it was found that the following relation had to be established in order to change the flow rate of gas and thereby keep the drawing speed to a set value.

$$\Delta W = g_i(V\phi - V) \quad (1)$$

Here,

$\Delta W$  represents the quantity of change of the flow rate of gas (cc/min).

$V\phi$  represents a set drawing speed (mm/min).

$V$  represents a drawing speed (mm/min).

$g_i$  represents a constant.

$g_1: V\phi - V \geq 0$

$g_2: V\phi - V < 0$

where:  $g_2 \geq g_1 > 0$

This is because the flow rate of gas is rapidly decreased so as to prevent optical fibers from being broken when the drawing speed becomes higher than the set value.

Further, light from the light source is made incident into one of the two optical fibers and the light coming out of the two optical fibers is monitored to measure the branching ratio, SR during drawing of the two optical fibers so that a fixed relation can be established between the set drawing speed  $V\phi$  and SR.

$$V\phi = F(SR) \quad (2)$$

The function of  $F(SR)$  may be selected to be  $e^{-SR}$ ,  $SR^{-n}$ , or the like to thereby decrease the drawing speed  $V$  as the branching ratio approaches to a desired value  $SR^*$  as shown in Fig. 2. In this condition, the drawing speed becomes low as the branching ratio approaches to the final target value so that the branching ratio can be easily obtained with high precision.

As an example of the utility of the method of the present invention, a coupler having a branching ratio of 50% was produced by using an apparatus for producing an optical-fiber coupler shown in Fig. 1. In the drawing, the reference numeral 1 designates a furring table; 2a and 2b, drawing stages; 3, clamps; 4a and 4b, optical fibers; 5, optical-fiber exposed portions; 6, a burner; 7a and 7b, control-

lers for controlling the flow rate of flaming gas; 8a and 8b, weights for applying constant tension to the optical fibers; 9, a light source; 10a and 10b, photo-detectors; 11a and 11b, detectors for measuring the distance of movement of the drawing stages; and 12, a computer.

A pair of clamps 3 are provided on the furring table 1 so as to be in opposition to each other through the drawing stages 2a and 2b and the two optical fibers 4a and 4b having the exposed portions 5 in which the respective coatings of the optical fibers are partially removed are fixed to the clamps 3. The exposed portions 5 are fixed so as to be disposed between the clamps 3 and 3, and the burner 6 which is a heat source, is disposed just below the exposed portions 5. The exposed portions 5 of the optical fibers are heated by the burner 6 and the drawing stages are pulled in directions opposite to each other so as to enlarge the distance of the exposed portions 5 to thereby form a predetermined coupler.

By using a burner having a plurality of gas ejection outlets, 6b, arranged along the axial direction of the optical fibers as shown in Fig. 3 of the burner, 6, it was possible to realize a fixed temperature all over the area to be heated. Therefore, the burner was fixed to perform heating.

Constant tension was applied to the exposed portions, 5, by the weights, 8a and 8b, attached on the drawing stages, 2a and 2b, respectively in Fig. 1. Propane gas and oxygen gas flowing, as flaming gas, into the burner, 6, are respectively supplied by the flow rate controllers, 7a and 7b which operate under instructions from the computer, 12.

Further, the computer receives the outputs from the detectors, 11a and 11b, for detecting the distance of movement of the drawing stages and the outputs of the photo-detectors, 10a and 10b, for detecting the intensity of light which is emitted from the light source, 9, and made to come out from the optical fibers, 4a and 4b, through the exposed portions, 5, constituting a coupler. The computer, 12, calculates the drawing speed  $V$  and the branching ratio SR on the basis of those inputs to the computer. Moreover, the computer 12 calculates  $\Delta V$  by using the foregoing expression (1) to thereby operate the flow rate controllers, 7a and 7b.

When 100 optical-fiber couplers were produced so as to have a branching ratio of 50%, all the couplers had a branching ratio which fell within a range of  $50 \pm 3\%$ , and the drawing time per coupler was one minute.

In summary, by the method according to the present invention, it is possible to consistently produce optical-fiber couplers with branching ratios within a desired range with a high degree of precision.

**Claims**

1. A method of producing an optical-fiber coupler comprising the steps of:
  - contacting a plurality of optical fibers to form a coupler forming portion; 5
  - heating the coupler forming portion with a flaming gas from a heat source;
  - drawing the optical fibers at a drawing speed under constant tension; 10
  - measuring the branching ratio of said coupler continuously during said drawing;
  - measuring said drawing speed; and
  - regulating the quantity of said flaming gas proportional to the difference between said drawing speed and a preset drawing speed, wherein said preset drawing speed is made a function of said branching ratio. 15
2. The method of producing an optical-fiber coupler according to Claim 1, wherein said function is calculated so that said drawing speed approaches zero as said branching ratio approaches a final target value. 20
3. The method of producing an optical-fiber coupler according to Claim 1, wherein said heating step comprises the step of heating with a plurality of gas ejection outlets arranged along the axial direction of said optical fibers. 25 30

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FIGURE 1

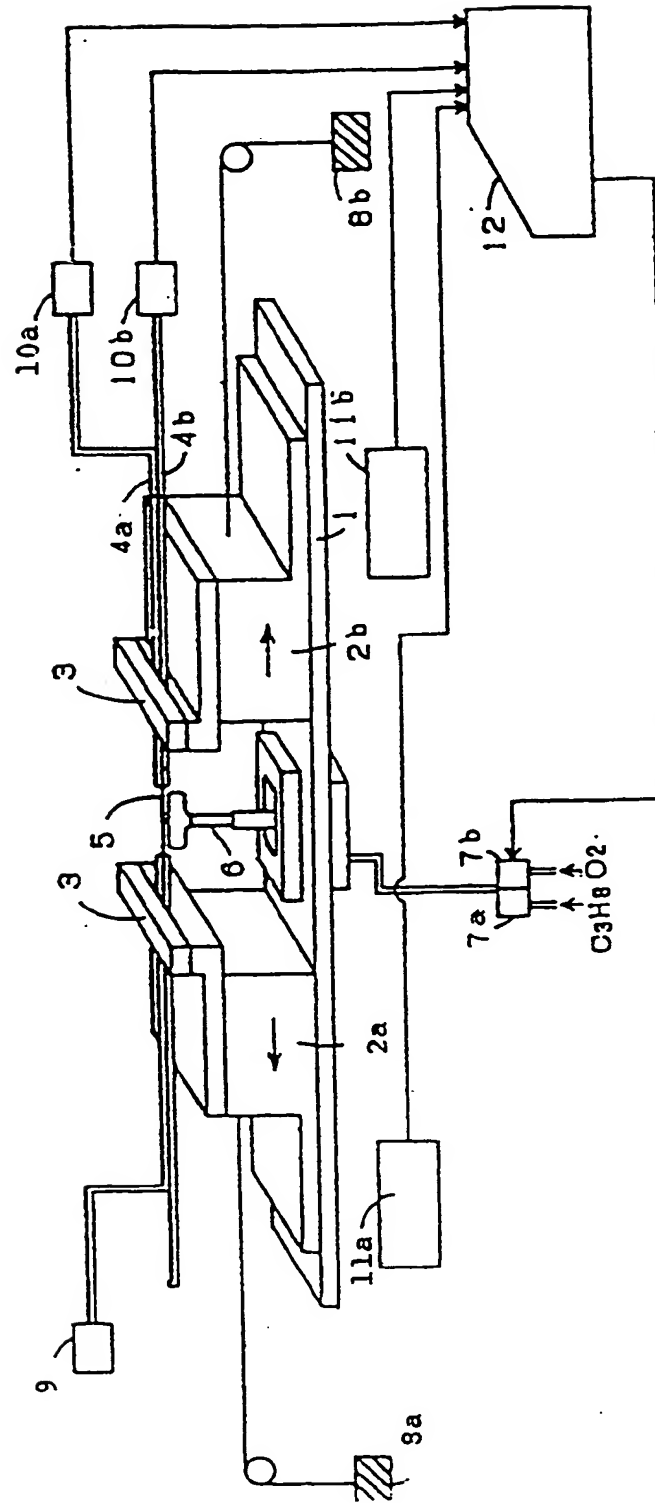


FIGURE 2

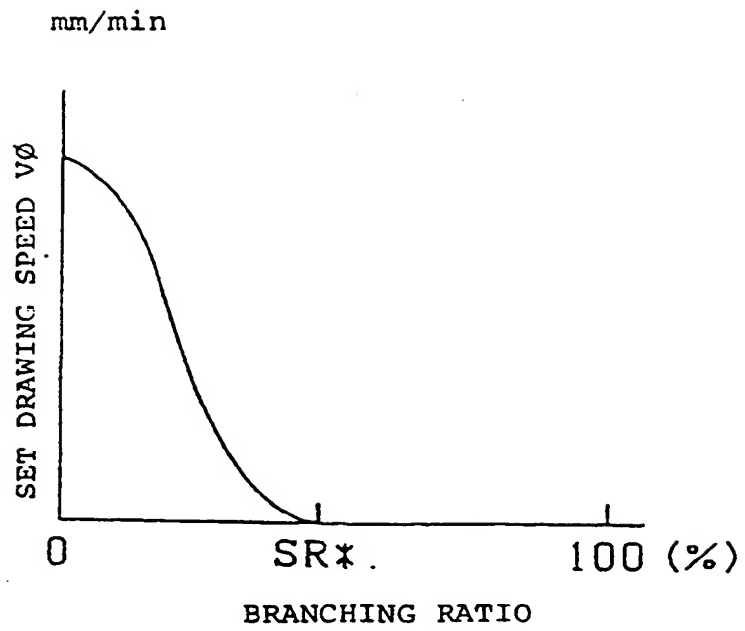


FIGURE 3

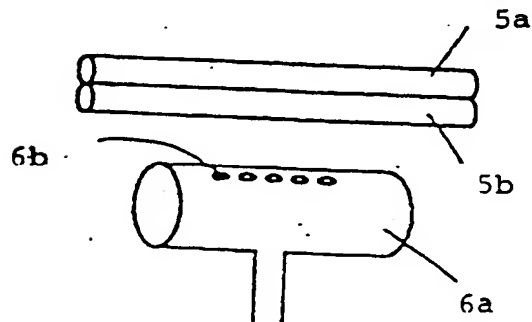
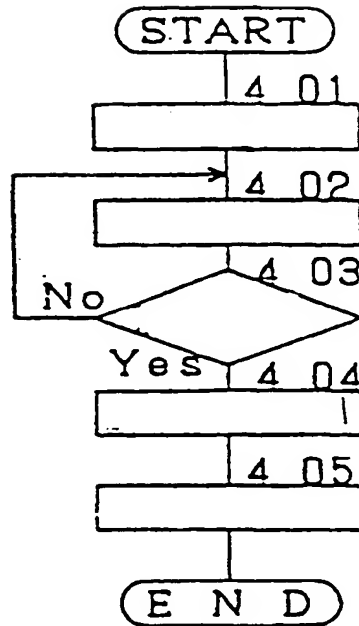


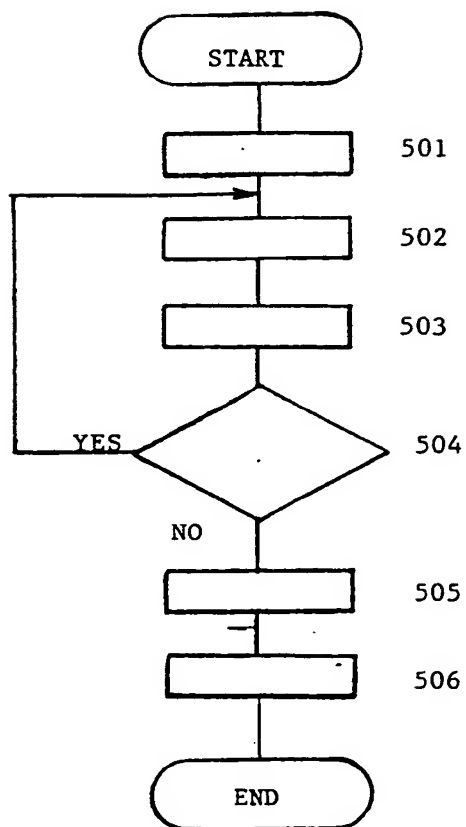
FIGURE 4



LEGEND:

- 401: Partly removing respective coatings
- 402: Drawing/fusing
- 403: Predetermined branching ratio?
- 404: Stop drawing/fusing
- 405: Fixed to protection member

FIGURE 5



## LEGEND:

- 501: Contacting optical fibers
- 502: Heating/drawing/fusing
- 503: Measuring branching ratio and drawing speed
- 504: Increase/decrease heating?
- 505: Stop heating/drawing/fusing
- 506: Fixed to protection member



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(21) Application number: 92102492.3

(51) Int. Cl.<sup>5</sup>: **G02B 6/28**

(22) Date of filing: 14.02.92

(30) Priority: 19.02.91 JP 24353/91

(43) Date of publication of application:  
26.08.92 Bulletin 92/35(86) Designated Contracting States:  
DE ES FR GB IT NL(88) Date of deferred publication of the search report:  
21.07.93 Bulletin 93/29

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(54) **Method of producing optical-fiber coupler.**

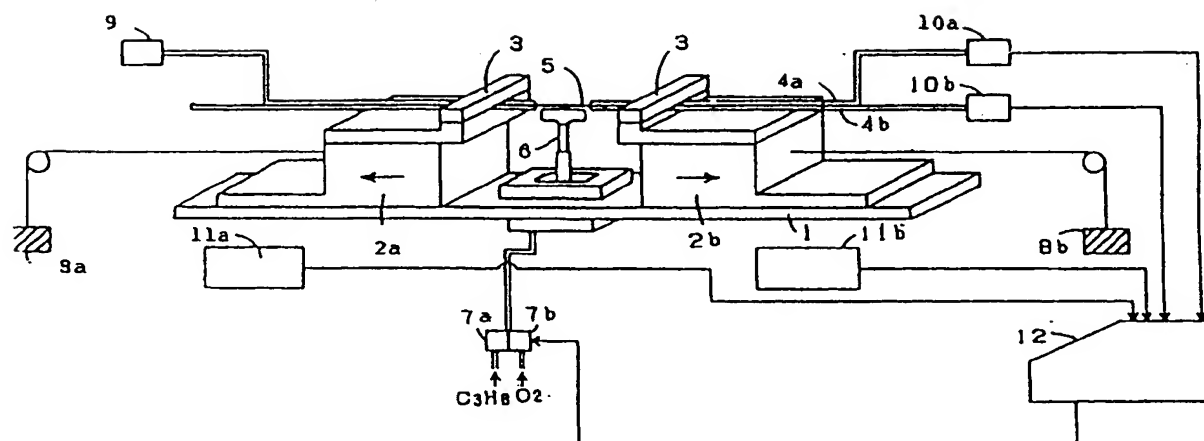
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der the instruction from computer (12).

Further, the computer (12) receives the outputs from the detectors, (11a) and (11b), for detecting the distance of movement of the drawing stages and the outputs of the photo-detectors, (10a) and (10b), for detecting the intensity of light which is emitted from the light source (9), and made to come out from the optical fibers, (4a) and (4b), through the exposed portions (5), constituting a coupler. The computer (12) calculates the drawing speed V and the branching ratio SR on the basis of those inputs to the computer. Moreover, the computer (12) calculates  $\Delta V$  by using the foregoing expression to thereby operate the flow rate controllers, (7a) and (7b).

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FIGURE 1





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## EUROPEAN SEARCH REPORT

Application Number

EP 92 10 2492

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
A	US-A-4 763 272 (MCLANDRICH M.N.) * column 10, line 3 - line 47 * * column 11, line 17 - line 27 * * column 12, line 1 - line 26 * * claims; figures 2,3 * ---	1	G02B6/28
A	AU-B-619 698 (THE COMMONWEALTH OF AUSTRALIA) * page 5, line 11 - line 16 * * page 13, line 17 - line 34 * * page 14, line 1 - line 13 * * claims; figures 1,2 * ---	1,2	
A	EP-A-0 370 465 (SUMITOMO ELECTRIC) * claims; figure 5 * ---	1,3	
A	US-A-4 895 423 (BILODEAU F. ET.AL.) * column 3, line 67 - line 68 * * column 4, line 168 * * column 5, line 1 - line 9 * * figure 3 * -----	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			G02B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 12 MAY 1993	Examiner MATHYSSEK K.
<b>CATEGORY OF CITED DOCUMENTS</b> X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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